

5/08

DART AEROSPACE LTD	Work Order:	21818
Description: Saddle billet	Part Number:	D6101-007
Drawing: D6101 Rev. A	Qty:	100

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	HA	04.10.27	100
2	PURCHASING	Issue P/O: <u>700 7053</u> a) Description: Alluminum billet b) 7.750" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.750" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	W	04.10.28	100
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	05/01/24	100
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	E	05/01/26	100
5	STORES	Identify & stock	HA	05.1.26	100
6	EXPEDITING	Close W/O Cost / part <u>103.23</u> <u>540</u> <u>05/01/27</u> <u>100</u> Inspect Level 21 <u>102.16</u>	HA	05.01.27	100

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

KF

03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

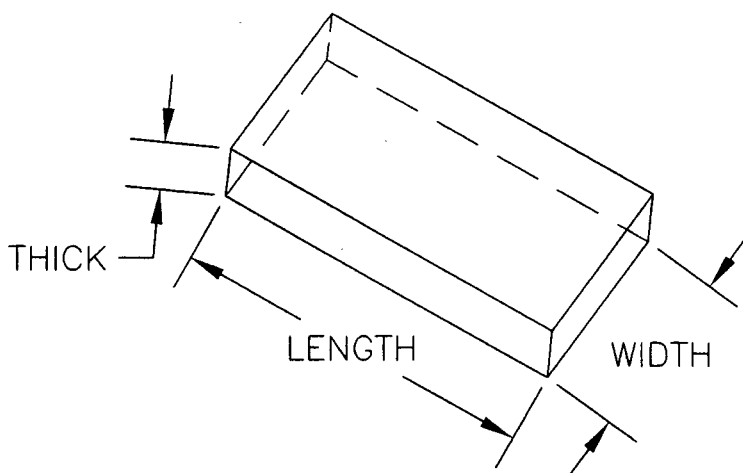
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21818

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 27, 2004
02:15 pm

Work Order No	: 0021818	Department Code:	
Project Name	: D6101-007	Burden Flags	: NNNNNNNN
Project For	: WK508	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-007	Invoice Number	:
Description	: 7075-T7351 8.25X7.75X2.5	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 100	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 10-27-04	Actual Margin	: 0.000%
Est Finish Date	: 02-15-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

PECHINEY ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164

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COPPER & BRASS-TMK DIVISION
5450 E. HOME
FRESNO CA

93727

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COPPER AND BRASS SALES
P.O. BOX 5116
SOUTHFIELD MI

48086

COPPER&BR

J95403 1512

INCLUSION

SERIAL#: 20041217J95403

2

CUSTOMER PURCHASE ORDER NO. & ITEM W18322				PECHINEY ORDER NO. 050-845401	
ALLOY 7075	CLAD. 00	TEMPER T7351	GAUGE 3.00000	WIDTH 48.500	LENGTH 144.500
ITEM ORDERED MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION AMS-QQ-A-250/12					
PART NUMBER 091567-8			B/L NUMBER J95400		DATE SHIPPED 12/19/04
WEIGHT SHIPPED 6,405		NO. OF PIECES 3		GOVT. CONTRACT NO.	

CERTIFICATION

"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

PECHINEY ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164

JODY S. THYEN, LABORATORY SPECIALIST

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.									
ACTUAL CHEMICAL COMPOSITION																			
309521			SI=0.07	FE=0.11	CU= 1.5	MN=0.01	MG= 2.6	CR=0.19	ZN= 5.6	TI=0.02									
			OTHERS-EACH: .05		MAX. OTHERS TOTAL: .15		MAX. AL REMAINDER												
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			